

## ABSTRACT OF THE DISCLOSURE

A multi-layer film bag with fusible inner layer has gussets fused to front and rear bag walls. Upper end areas of the gussets are folded over toward one bag wall at a folding line to form folded-over end areas. The folding line is oriented at a slant inwardly and downwardly. The inner side of the folded-over end areas is fused by a first welding seam to an inner side of a neighboring gusset half. The outer side of the folded-over end areas is fused by a second welding seam to a neighboring bag wall. An area of the neighboring gusset half adjoining the folded-over end areas is fused by a third welding seam to a neighboring bag wall. The first, second, and third welding seams form a fused connection closing off the top edges of the folded-over end areas.